

Work Order ID 128182

Monday, January 12, 2015 10:37:06 AM

128182

Page 1

Item ID: D412-698-028

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket, Aluminum Door RH

Stop ***NS2***

Start Date: 1/12/2015 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 1/12/2015 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 1501-12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9484	C

100	Document Control	0.00
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100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile & type labels per PPP D412-698-028/ DSI9484
CHG003

DAS
27
FEB 25 2015
u 1502.25

110	Pick Kit	0.00
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110

Packaging

Packaging

Memo

0.00

u 15.02.25

DAS
28
9-89

120	QC4- 100% Inspect kits for completeness	0.00
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120

QC

Quality Control

Memo

0.00

YX DAS
27
9-89

FEB 25 2015

Work Order ID 128182

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128182

Page 2

Item ID: D412-698-028 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket, Aluminum Door RH
Start Date: 1/12/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/12/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-028/ DSI 9484 Location: <u>FG 122</u> PPP rev: _____ X1 SOLD								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

4
DAG
27
8:59
FEB 25 2015
MCS 15-02-25
ME
15-2-25

Picklist Print

Monday, January 12, 2015 10:37:09 AM

Page 1

Work Order ID: 128182

128182

Parent Item: D412-698-028

D412-698-028

Parent Item Name: Bracket, Aluminum Door RH

Start Date: 1/12/2015

Required Date: 1/12/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
11.03.31 AS PER ECN11-531 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3199-4		Manufactured	No			110	Each	24.0000	1	4			

D3199-4

Bracket, Fwd RH

DAS
27
9-89

Location

ST026

77735

Loc Qty

24

24

Loc Code

DAS
28
9-89

u 15-02-25

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E OR LATER APPROVED REVISION
AND ICA-D412-698 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43
REF. FAA STC: SR01446NY
REF. EASA.IM.R.S.00709

Field experience has shown that the forward D3199-1 brackets that are part of the D412-698-011/-012/-017 Cabin Door Roller Kits and forward D3675-1 brackets that are part of the D412-698-031/-032/-033 Cabin Door Roller Kits may wear prematurely if the aircraft is flown a significant amount of time with the sliding doors open. Dart has developed the D412-698-027/-028 kits that includes a longer D3199-3/-4 bracket for installation in the first forward position of the D412-698-011/-012/-017 kits to reduce wear on these forward brackets on aircraft equipped with aluminum doors. Likewise, Dart has developed the D412-698-037/-038 kits that includes a longer D3675-5/-6 bracket for installation in the first forward position of the D412-698-031/-032/-033 kits to reduce wear on these forward brackets on aircraft equipped with composite doors.

The D412-698-027/-028/-037/-038 kits may be installed as follows:

- 1) Remove the sliding door from the aircraft per Section 52.1 of ICA-D412-698
- 2) Remove the first forward D3199-1 or D3675-1 brackets as applicable.
- 3) Install the D3199-3/-4 or D3675-5/-6 bracket as applicable in lieu of the removed -1 bracket. Refer to Figure 1 Sheet 2 (aluminum doors) or Figure 2 Sheet 3 (composite doors).
- 4) Torque hardware per ICA-D412-698.
- 5) Re-install sliding door on aircraft per Section 52.2/52.3 of ICA-D412-698 as applicable.
- 6) Make entry in technical records of aircraft indicating that DSI 9484 has been completed.

PARTS LIST

QTY. -027	QTY. -028	QTY. -037	QTY. -038	PART NUMBER	DESCRIPTION
X				D412-698-027	BRACKET KIT, LH (ALUMINUM DOORS)
	X			D412-698-028	BRACKET KIT, RH (ALUMINUM DOORS)
		X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
			X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
1				D3199-3	FORWARD BRACKET, LH
	1			D3199-4	FORWARD BRACKET, RH
		1		D3675-5	FORWARD BRACKET, LH
			1	D3675-6	FORWARD BRACKET, RH

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal		Applicability
		Arm	Moment	Arm	Moment	
D412-698-027 Bracket Kit	0.16 lb 0.07 kg	-48.0 in -1.22 m	-7.68 in-lb -0.09 m-kG	102.3 in 2.60 m	16.37 in-lb 0.18 m-kG	Aircraft Equipped with P/N 205-032-669-XXX Aluminum Doors
D412-698-028 Bracket Kit	0.16 lbs 0.07 kg	+48.0 +1.22 m	+7.68 in-lb +0.09 m-kG	102.3 in 2.60 m	16.37 in-lb 0.18 m-kG	
D412-698-037 Bracket Kit	0.18 lb 0.08 kg	-48.0 in -1.22 m	-8.64 in-lb -0.10 m-kG	102.3 in 2.60 m	18.41 in-lb 0.21 m-kG	Aircraft Equipped with P/N 412-030-300-XXX Composite Doors
D412-698-038 Bracket Kit	0.18 lb 0.08 kg	+48.0 in +1.22 m	+8.64 in-lb +0.10 m-kG	102.3 in 2.60 m	18.41 in-lb 0.21 m-kG	

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.03.21
CERT. NO.: SH92-43
ISSUE NO.: 5

C	UPDATED -027/-028/-037/-038 KITS AND INSTALLATION	MB	11.03.21
B	ADDED -037/-038 KIT FOR COMPOSITE DOORS; UPDATED TITLE ACCORDINGLY.	MB	10.12.17
A	NEW ISSUE	<i>[Signature]</i>	09.10.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	NA	DSI 9484	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	D412-698-027/-028/-037/-038 Kits	NTS
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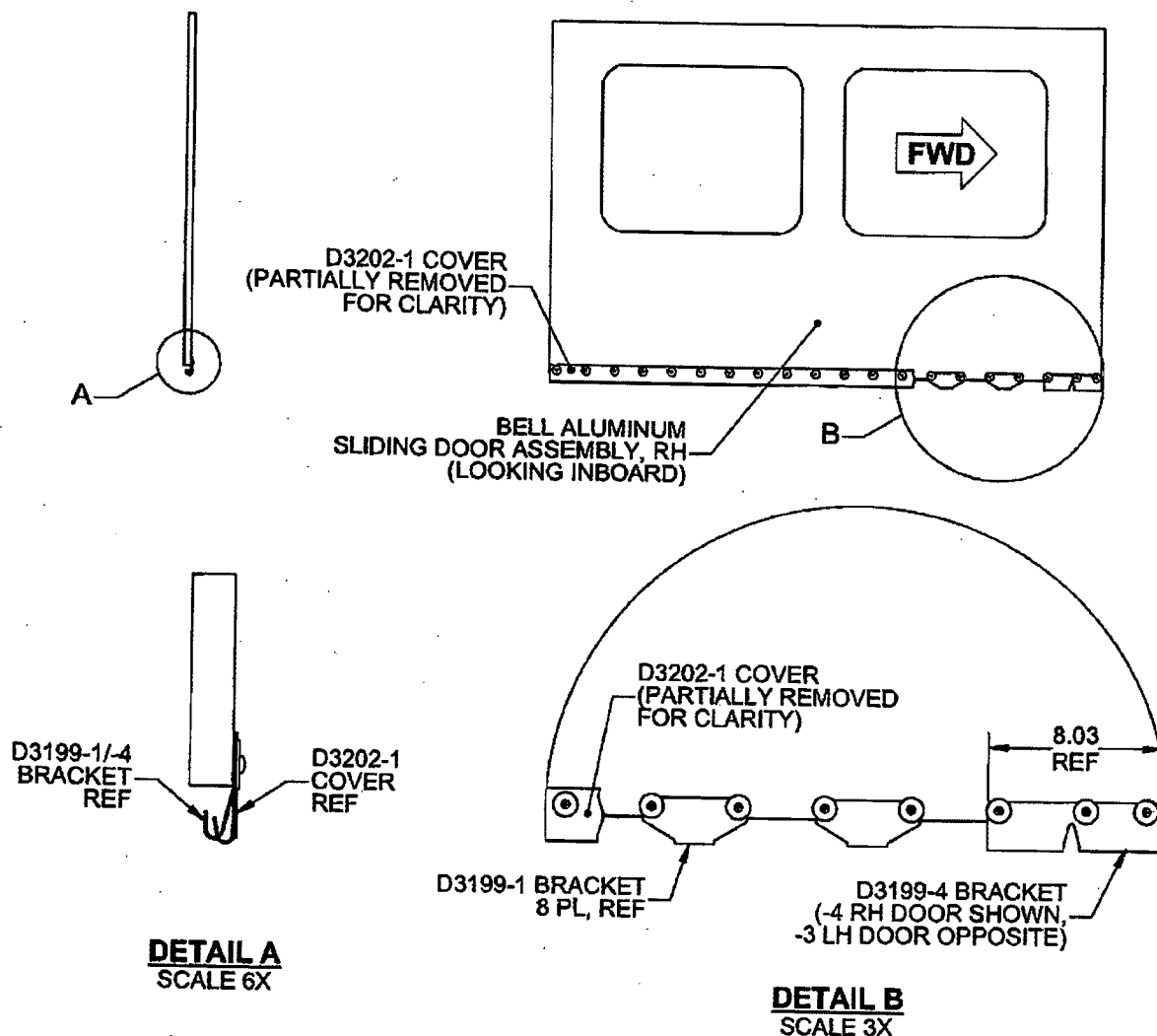


FIGURE 1: D3199-3/-4 BRACKET INSTALLATION ON ALUMINUM DOORS
(-4 SHOWN, -3 OPPOSITE)

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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DATE: 11.03.21
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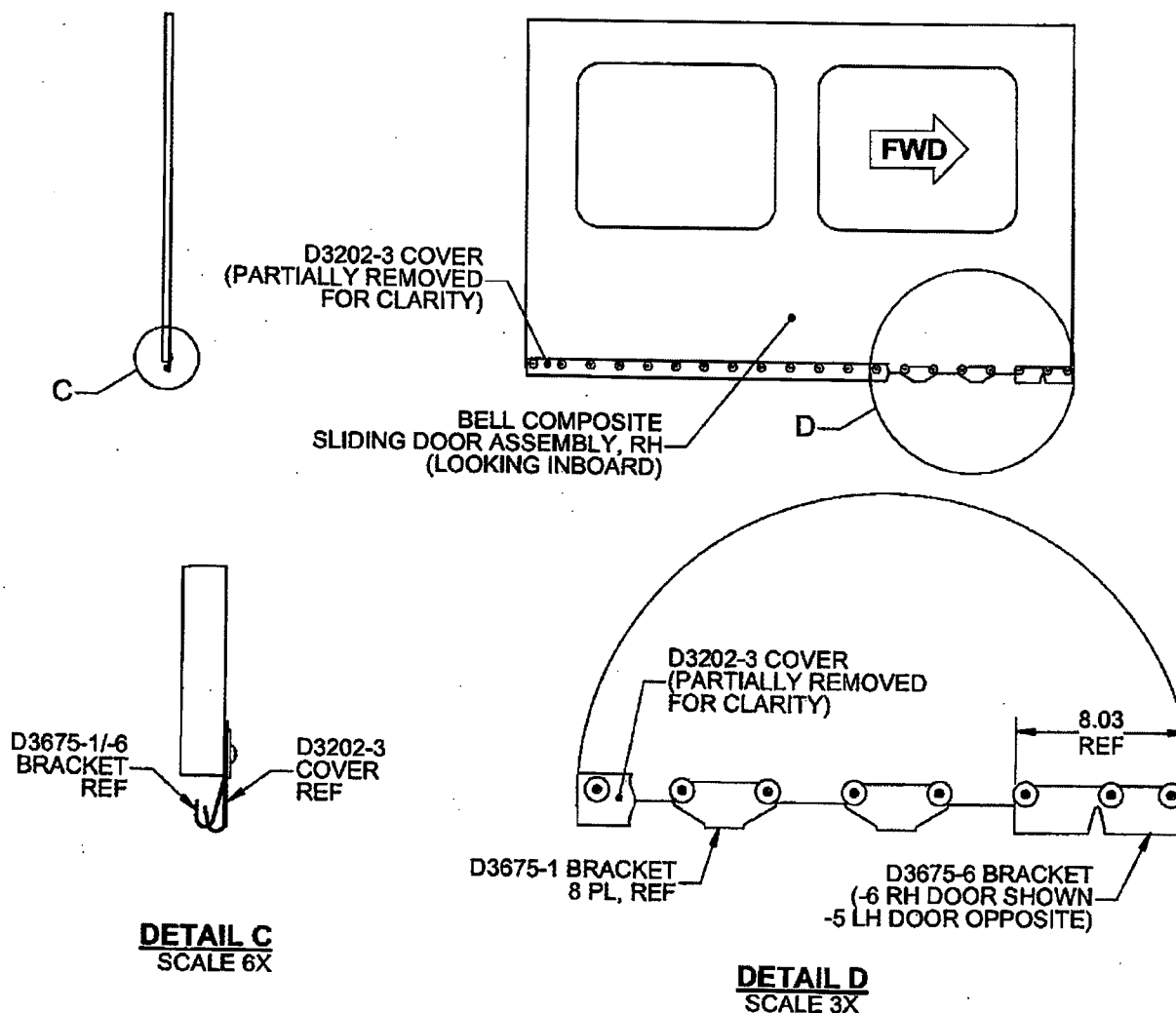


FIGURE 2: D3675-5/-6 BRACKET INSTALLATION ON COMPOSITE DOORS
(-6 SHOWN, -5 OPPOSITE)

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BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.03.21
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MFG. APPR.	N/A	DSI 9484	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		D412-698-027/-028/-037/-038 Kits	NTS
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